

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013601**Date Inspected:** 04-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 7AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA031-004. The welder is identified as #045196 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1 UT repair for CWR 1229.

This QA Inspector observed ABF personnel performing Magnetic Particle Testing (MT) on Base Metal Repairs ground flush on Deck Plate at panel point 50-52 at cross beam connection location.

Segment 7BE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD27-PP051-221. The welder is identified as #054467 and was

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

Segment 7BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SSD25-PP051-221. The welder is identified as #220069 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-T-2234-TC-U4b-F.

Segment 7CE

This QA Inspector observed match drilling of Side Plate WT stiffener flange, bike path side.

This QA Inspector observed Heat Straightening of the Longitudinal Diaphragm flange at panel point 53 west bike path side following HSR1(B)-8249

Segment 7BE/7CE

This QA Inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on interior of Bottom Plate CJP transverse splice.

Segment 7EE

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) of the Deck Plate to Edge Plate CJP splice, cross beam and bike path side. D scan was performed.

ZPMC Quality Control (QC) Inspector is identified as Fang Ya Jun. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
